

**Work Order ID 76452****\*76452\***

Tuesday, November 15, 2011 9:20:45 AM

Page 1

Item ID: D3391-025

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Aft Tube Assembly

Stop

**\*NS2\***Start Date: 11/14/2011 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 11/16/2011 Req'd Qty: 1.00 **\*1\***

Customer:

Reference: REWORK PER REV I

Approvals:	Process Plan: <i>MW</i>	Date: 11-11-15	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
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D3391	1	0.00							
-------	---	------	--	--	--	--	--	--	--

300	0.00								
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**\*300\***

Packaging

Packaging

Memo 0.00

PULL FROM STOCK D3391-025 B73013

AND BRING TO FINISHING *[Signature]*

310	0.00								
-----	------	--	--	--	--	--	--	--	--

**\*310\***

Skidtubes

Skidtubes

Memo 0.00

REMOVE WEARPLATES AND PUT BACK INTO STOCK :

REMOVE GASKETS AND SCRAP

D3537-1 X 1  
 D3537-7 X 1  
 D3553-1 X 1  
 D3553-3 X 1

DISCARD HARDWARE AND PICK NEW

RE-ASSEMBLE WITH NEW WEARPLATES AND NEW HARDWARE

*To Rev I**BL 11-11-17**I BR 11-11-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 76452**

Tuesday, November 15, 2011 9:20:45 AM

**\*76452\***

Page 2

Item ID: D3391-025

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Aft Tube Assembly

Stop

**\*NS2\***

Start Date: 11/14/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 11/16/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference: REWORK PER REV I

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
Description

320

QC5- Inspect part completeness to step on W/O

**\*320\***

QC

Quality Control

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

S wluft

0.00

330

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*330\***

Packaging

Packaging

S4m

340

QC21- Final Inspection - Work Order Release

0.00

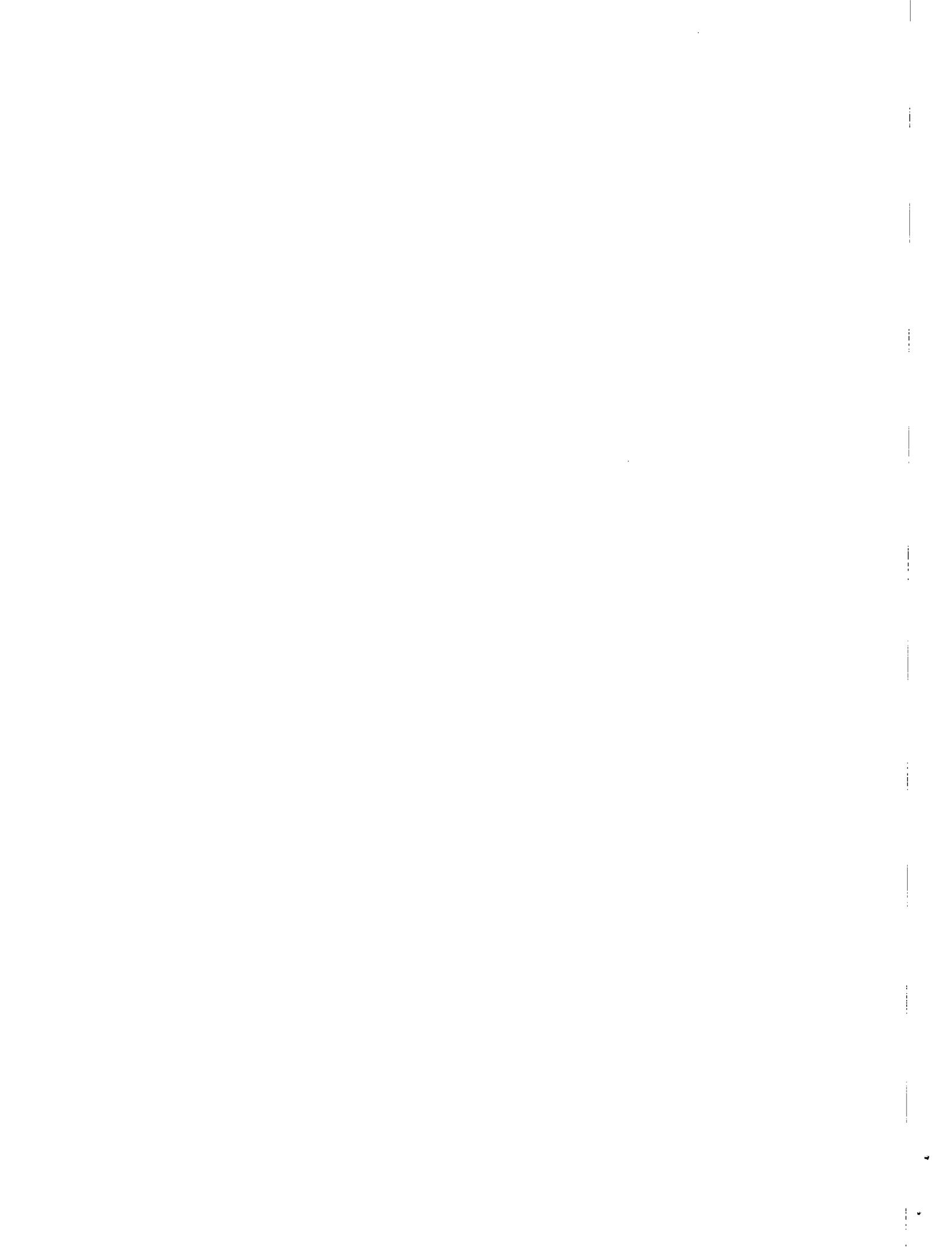
**\*340\***

QC

Quality Control

M4m

0.00





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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Tuesday, November 15, 2011 9:20:44 AM

Page 2

Work Order ID: 76452

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/14/2011

Required Date: 11/16/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A  
BOLT

Purchased No

Each 2,101.0000

6

BL 11-11-17-

Location	Loc Qty	Loc Code
ST350	2101	
117313	2	
117688	5	
117872	22	
118112	16	
118451	2	
118706	92	
118838	962	
119328 ✓	1000	

AN3C5A  
Bolt

Purchased No

Each 987.0000

4

BL 11-11-17.

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	980	
116419	28	
117343	17	
117764	166	
117872 ✓	2	
118451 ✓	267	
119127	500	

AN960C10L  
washer

NAS1149C0332R ✓ Purchased

No

Each 0.0000

119124

⑩

BL 11-11-17.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, November 15, 2011 9:20:44 AM

Page 3

Work Order ID: 76452

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/14/2011

Required Date: 11/16/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Aft Cap

Manufactured No Each 243.0000 1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP002	226	
-------	-----	--

73294	26	
-------	----	--

73825	200	
-------	-----	--

FP004	5	
-------	---	--

68280	5	
-------	---	--

FP006	5	
-------	---	--

62678	5	
-------	---	--

FP-4	3	
------	---	--

70945	1	
-------	---	--

71070	2	
-------	---	--

fp5	4	
-----	---	--

71038	4	
-------	---	--

D3537-1

Wearpad

Manufactured No Each 80.0000 -1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP002	73	
-------	----	--

74436	56	
-------	----	--

74597	17	
-------	----	--

FP017	7	
-------	---	--

69817	5	
-------	---	--

70686	2	
-------	---	--

D3537-7

Wearpad

Manufactured No Each 19.0000 -1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP	4	
----	---	--

71689	4	
-------	---	--

FP001	12	
-------	----	--

74617	12	
-------	----	--

FP017	3	
-------	---	--

71689	3	
-------	---	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, November 15, 2011 9:20:45 AM

Page 4

Work Order ID: 76452

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 11/14/2011

Required Date: 11/16/2011

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

SPACER

Manufactured

No

Each

104.0000

4

D3672-1

Phenolic Washer

Manufactured

No

Each

688.0000

2

D4095-047

Wearpad Assembly

D4095-049

Wearpad Assembly

Manufactured

No

72229  
██████████  
76208

264  
76208

Each

0.0000

① BK 11-11-17

Manufactured

No

76217

Each

0.0000

① BK 11-11-17.

D3391-025

73013

IX

BK 11-11-17.

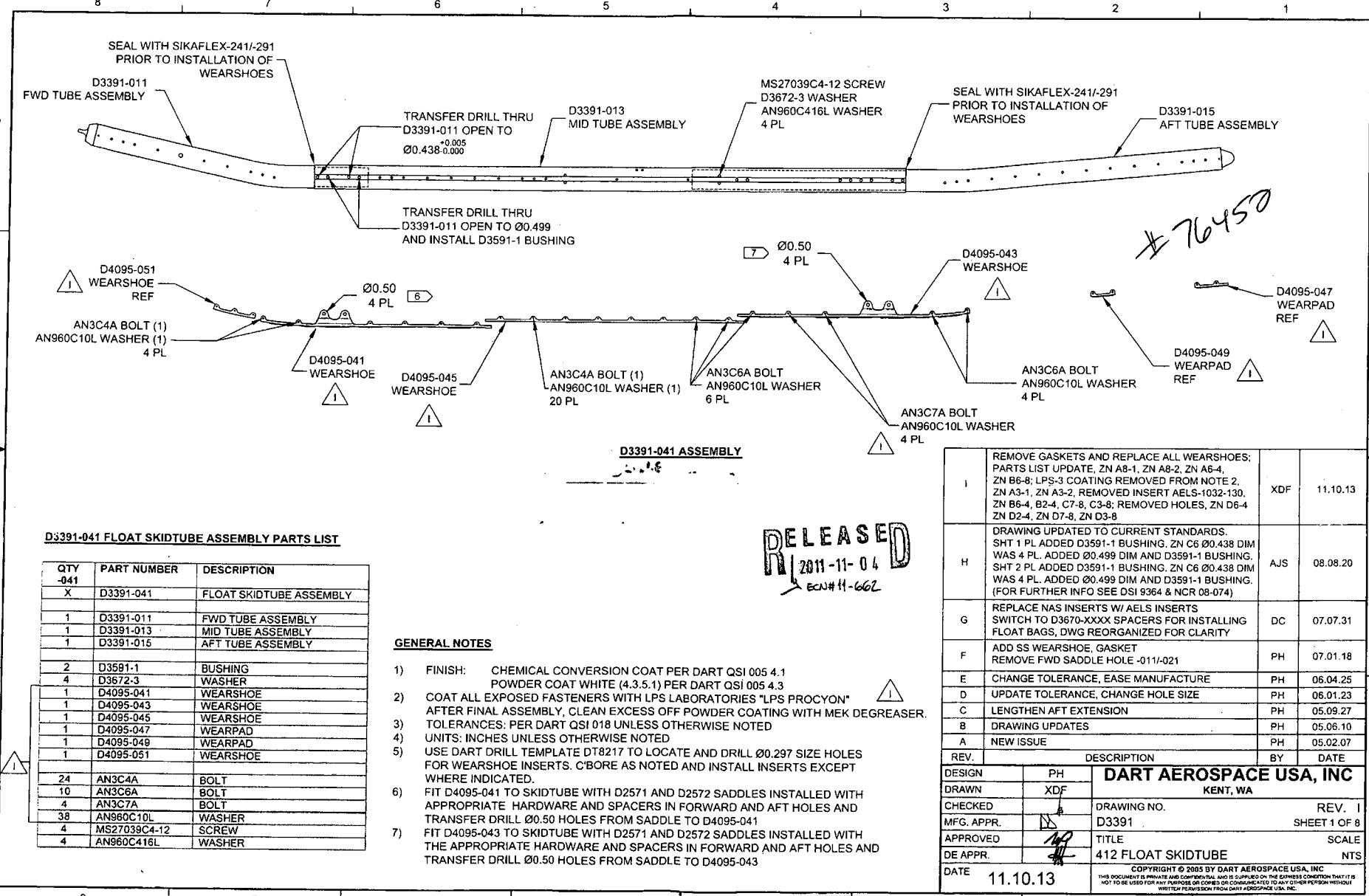
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

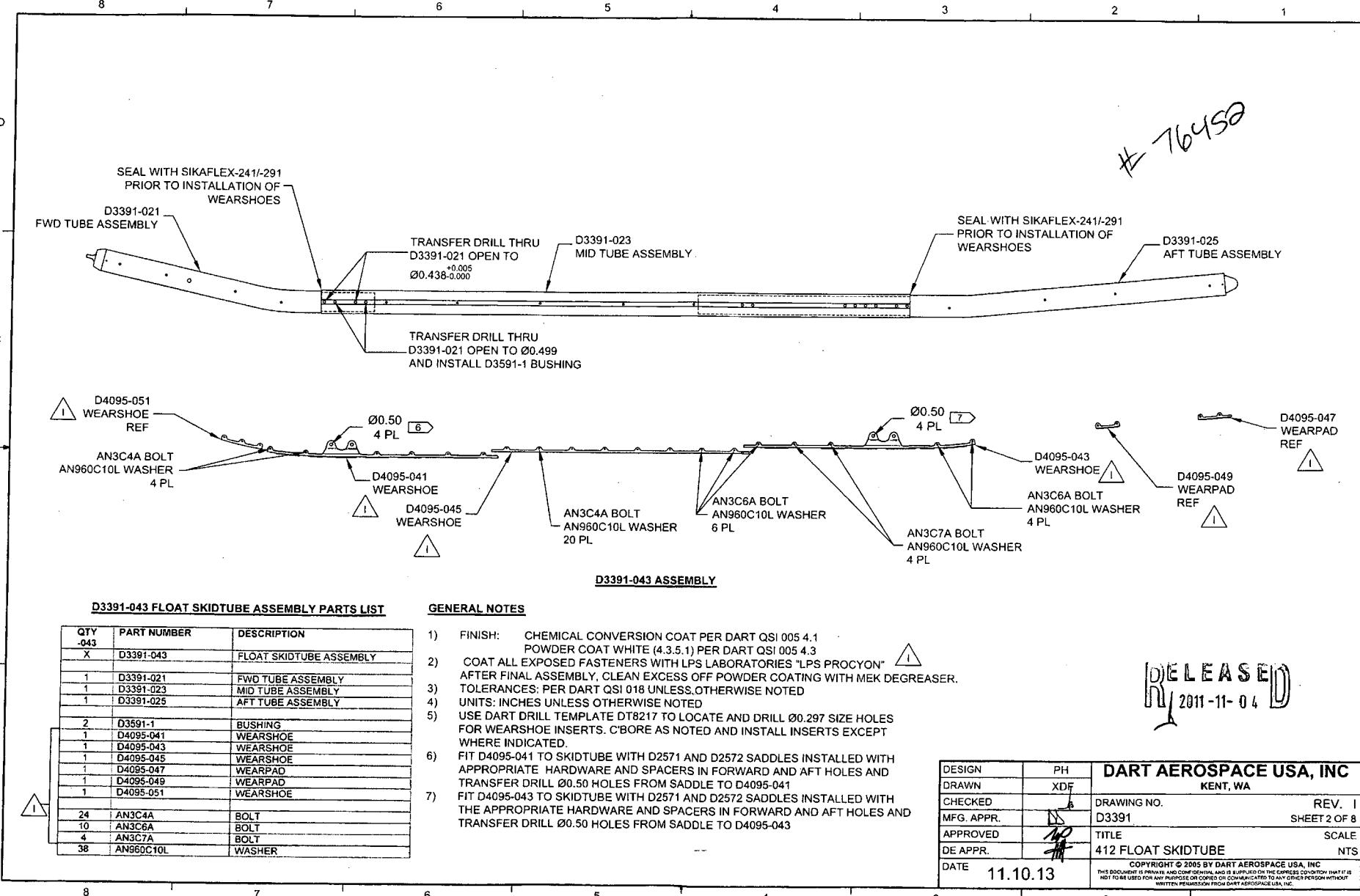
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

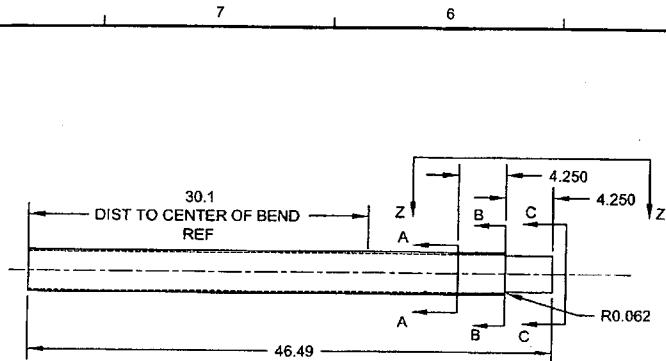
NOTE: Date & initial all entries



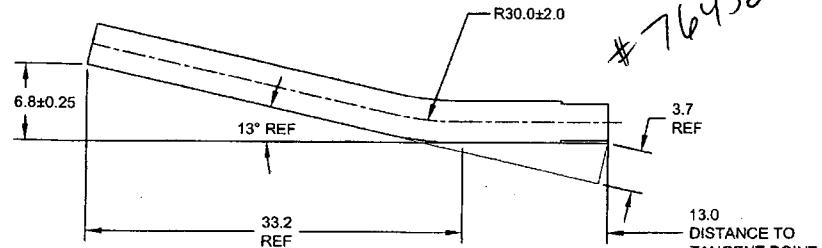




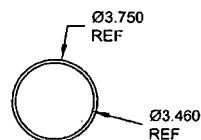




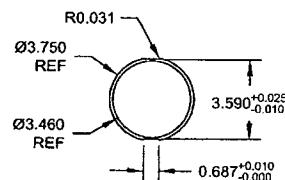
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



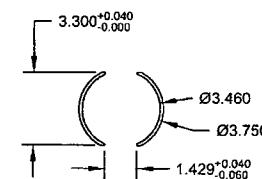
**D3391-011-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



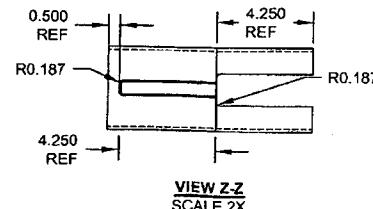
**SECTION A-A**  
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**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
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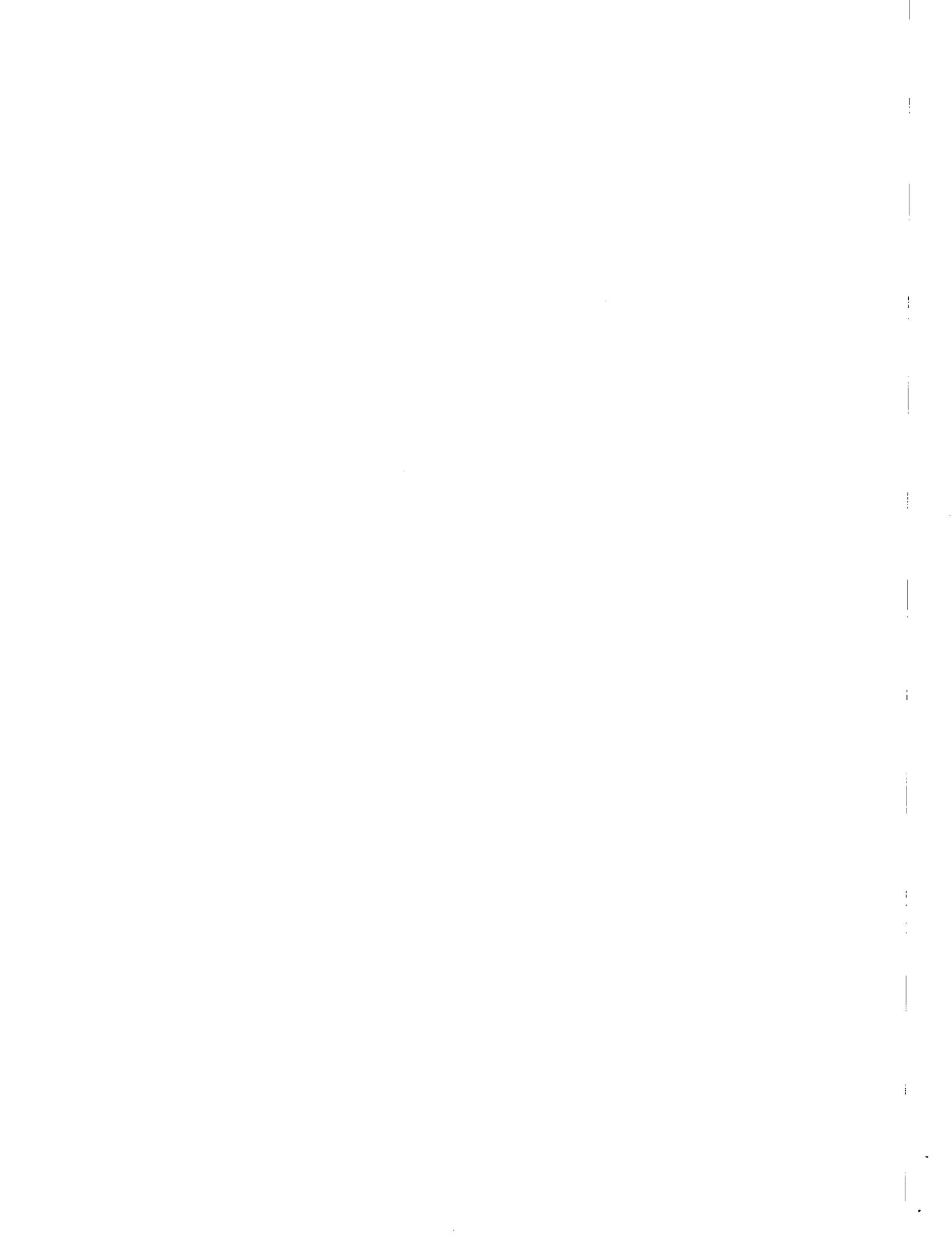


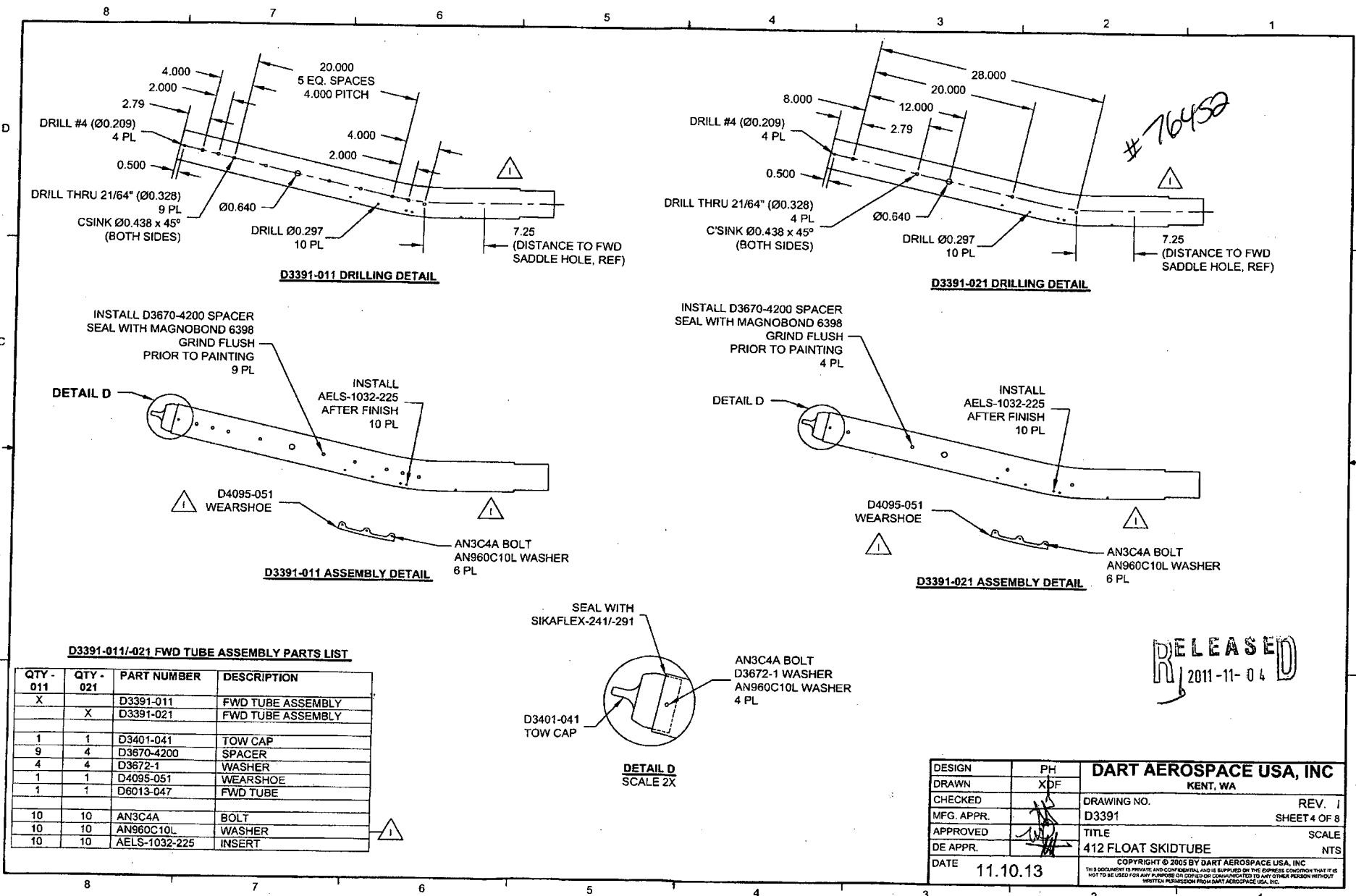
**VIEW Z-Z**  
SCALE 2X

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MFG. APPR.	NO	REV. I
APPROVED		D3391
DE APPR.		SHEET 3 OF 8
DATE	11.10.13	TITLE
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		NTS

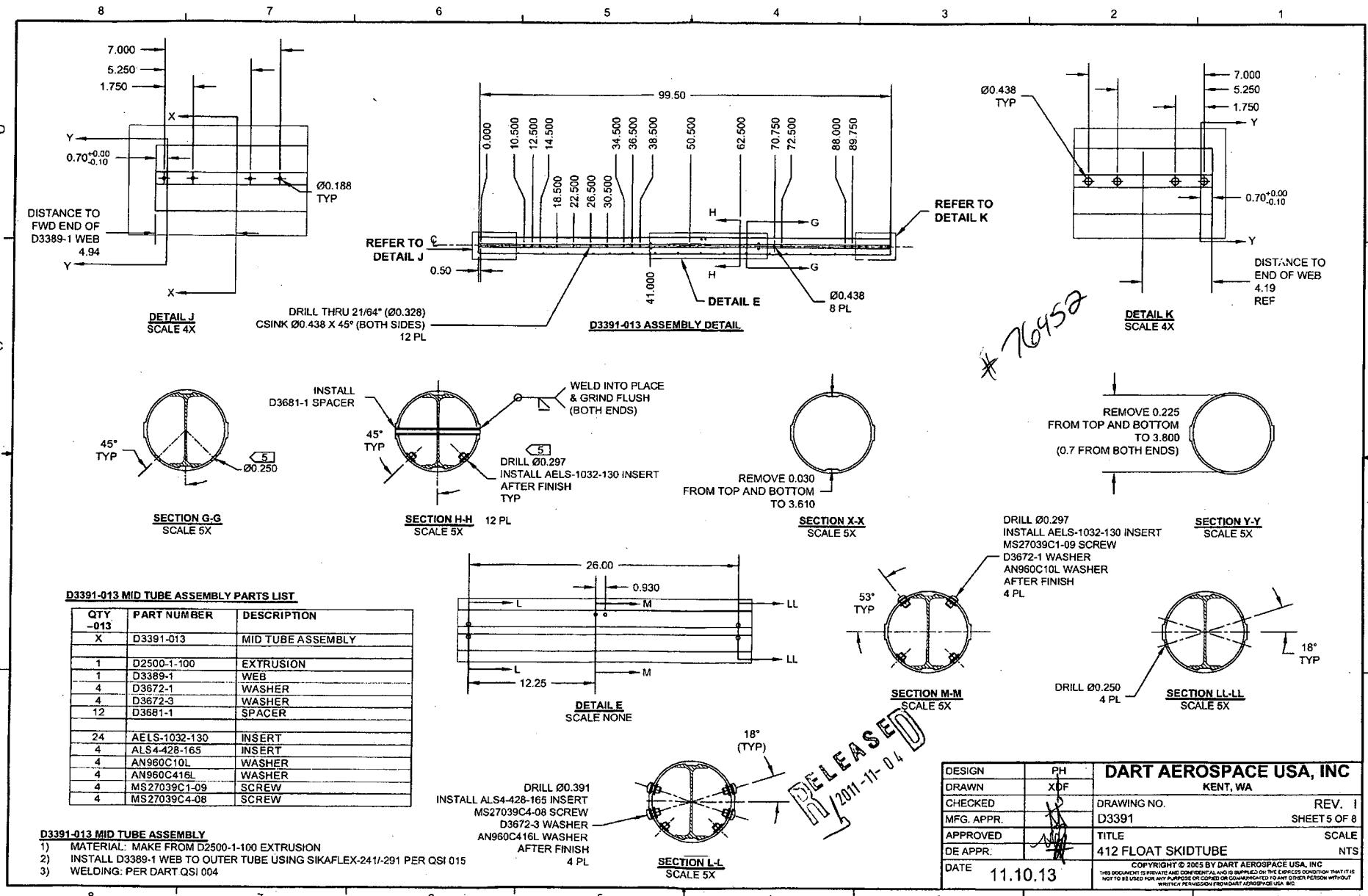
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RELEASED  
2011-11-04









RELEASED  
11/20/2011 BY ODA

DESIGN	PH	DART AEROSPACE USA, INC		
DRAWN	XDF	KENT, WA		
CHECKED	X	DRAWING NO.	REV. I	
MFG. APPR.		D3391	SHEET 5 OF 8	
APPROVED	X	TITLE	SCALE	
DE APPR.		412 FLOAT SKIDTUBE	NTS	
DATE	11.10.13			



